



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB H4713-1
Job Sheet 187013



Part No: RB H4713-1

Job Qty: 12 ea

Part Name: Drain Hose Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB H4713 Rev 4 IPP Rev A 18.02.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		12/28/18	0.00	0.00	Start Up Machining-4		
110	CNC Lathe	12 pcs		12/28/18	0.00	12.00	SL-154		
120	QC	12 pcs		12/28/18	0.00	0.00	QC2		
122	Mill Conv	12 pcs		12/28/18	0.00	3.00	Mill Conv 2		
127	QC	12 pcs		12/28/18	0.00	0.00	QC2 Machining-3		
130	QC	12 pcs		12/28/18	0.00	0.00	QC8		
150	Outsource	12 pcs		12/28/18			ATG001-VC	5	
160	Packaging	12 pcs		12/28/18	0.00	0.00	Packaging2		
170	QC	12 pcs		12/28/18	0.00	0.00	QC6		
180	Packaging	12 pcs		12/28/18	0.00	0.00	Packaging3		
190	QC21-SA	12 Ea		12/28/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG, FB944 FOLIO REV: AA DWG REV: 4-00 2-Debur
Descriptions: 120 - Engrave T/N and/or P/N number using Marktronic engraver as per DWG.
122 - 1-Mill flats as per DWG
150 - Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RB910-0020-1 Rev. 2

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.125	6061 Round Bar 1.125	.3360 ft (.028 ea)	90-Start up Operation	5123405

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.125	0	42	0



Container No: S138603



Part: RB H4713-1
Job No: 187013
Serial No/Batch: S138603

Revision: 4
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ations

not be found.

Plex 11/23/18 2:37 PM Dart.lajeunesse.marie

Date: 12/18/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
<table style="width:100%; border: none;"> <tr> <td style="width:25%; vertical-align: top;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:25%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:25%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:25%; vertical-align: top;"> FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:25%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:25%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>					Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
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OTHER : _____																					

DART AEROSPACE LTD		Work Order:	187013
Description: Body		Part Number:	
Inspection Dwg: RB H4713-1		Rev: 4	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.135	$\pm .005$	0.136	✓		Comm. JVD	
Ø1.06	$\pm .01$	1.063			Jern LPro	
Ø.430	$\pm .005$	.429				
Ø.312	$\pm .005$	.312				
.170	$\pm .005$	.170				
.59	$\pm .01$	.592				
1.160	$\pm .005$	1.160				
1.460	$\pm .005$	1.460				
.09	$\pm .01$	.090				
25°	$\pm .5°$	25.2°			Opt Comp	
1.55	$\pm .01$	1.555			Jern LPro	
1.35	$\pm .01$	1.350				
.080	$\pm .005$	.080				
.300	$\pm .005$	.300				
Ø.498	$\pm .001$	.498			Mic LPro	
Ø.500	$+ .000 / - .005$	.498				
Ø.470	$+ .000 / - .005$	.467			Jern LPro	
3.115	$\pm .005$	3.116				
Ø.610	$\pm .005$	.610				
Ø.320	$\pm .005$	.320				
.045	$\pm .005$	0.043				
.03 x 45°	$\pm .01 \times .5°$	.034 x 45°			Jern LPro	
.125	$+ .005 / - .000$	.125				
.090	$\pm .005$	.088				
.042	$\pm .005$	.043				
.235	$\pm .005$	.233				
.25	$\pm .01$	.252				
3.07	$+ .000 / - .01$	3.067				

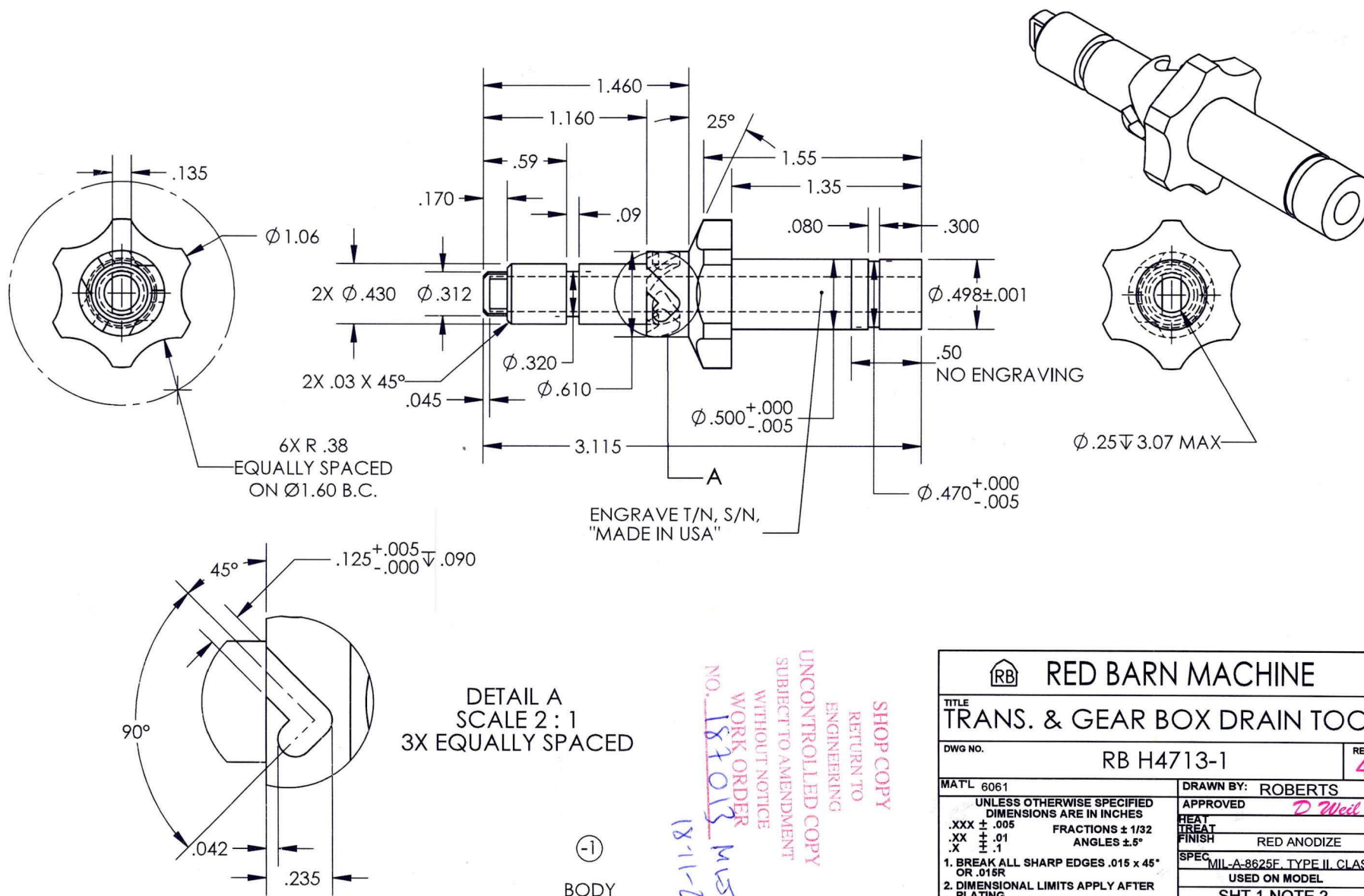
Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	18-12-18	Date:	18/12/21	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
3	INCREASED STEM LENGHT FROM .80 TO 1.35, REMOVED BARB ADDED GROOVE.	7/24/2012	JAG	RW
4	*1 CH'D ANGLE OF LOCK GROOVES SEAT WAS 60° IS 90°. CH'D DIM'S WAS .125 IS .125 +.005 -.000 ∇ .090, WAS ϕ .250 ∇ 3.07 IS ϕ .25 ∇ 3.07 MAX. DELETED 6X .11, (.244), (.096). ADDED NOTES WAS .50 IS .50 NO ENGRAVING, CH'D DIM WAS 6X R.38 IS 6X R.38 EQUALLY SPACED ON ϕ 1.60 B.C., CH'D NOTE WAS ENGRAVE T/N IS ENGRAVE T/N, S/N, "MADE IN USA".	2/12/14	DPD	GE



DETAIL A
SCALE 2 : 1
3X EQUALLY SPACED

(-1)
BODY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187013 M15
18-11-23

RED BARN MACHINE	
TITLE TRANS. & GEAR BOX DRAIN TOOL	
DWG NO. RB H4713-1	REV 4
MATL 6061	DRAWN BY: ROBERTS
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm$.005	HEAT TREAT
.XX $\pm$.01	FINISH RED ANODIZE
.X $\pm$.1	SPEC MIL-A-8625F TYPE II CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SHT 1 NOTE 2
SCALE 1:1	DATE 8/29/2000
SHEET 2 OF 2	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042128



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042128

PO Date: 12/24/18

Due Date: 1/4/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179109	RBW1205G00332-3G-24	End Cap -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	1/4/19	13 pcs	0 pcs	13 pcs	\$5.76/pcs	\$74.88
2	187013	RB H4713-1	Drain Hose Body -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RB910-0020-1 Rev. 2	Firmed	-	1/4/19	13 pcs	0 pcs	13 pcs	\$5.78/pcs	\$75.14

Line Item Note ** NEED BACK FIRST WEEK OF JAN **



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PURCHASE ORDER

PO042128



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	184748	RB DB3188L-3	Swivel -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE- 2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	1/4/19	13 pcs	0 pcs	13 pcs	\$5.78/pcs	\$75.14
4	187707	RBW1205G00332-3G-01	Cap -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	1/4/19	13 pcs	0 pcs	13 pcs	\$5.76/pcs	\$74.88
Grand Total:											\$300.04

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/7/19 7:48 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916934

Date: 07-Jan-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 13 each	Part: RBW1205G00332-3G-24 ✓ End Cap Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24387	Rev: F PO: PO042128 ✓	Line: 1
✓ 13 each	Part: RB H4713-1 ✓ Drain Hose Body Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils).Water Sealant, Job: 24389	Rev: PO: PO042128 ✓	Line: 2
✓ 13 each	Part: RB DB3188L-3 ✓ Swivel Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils).Water Sealant, Job: 24391	Rev: PO: PO042128 ✓	Line: 3
✓ 13 ea	Part: RBW1205G00332-3G-01 ✓ Cap Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24392	Rev: 6 PO: PO042128 ✓	Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JAN 07 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>For Doran</u>			
Made in Canada.			

DAS
38
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916934

Date: 07-Jan-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

DAS
38
9-89

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		